

Date: Thursday, 07/02/2008 2:55:19 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP BRACKET		
Job Number	: 37298			Part Number	: D37291		
Estimate Number	: 13161			Drawing Number	: D3729 U/R		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/02/2008	S.O. No.	:	Drawing Revision	: U/R		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 08/02/2008		
Previous Run	:			Qty:	6	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev.A 08-01-30 new issue DD verified by:EC						

POSITIVE  
RECALL

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"  M6061T6B0500X05000 x 06000 since 2008/08/08
		Comment: Qty.: 1.0062 f(s)/Unit Total : 6.0373 f(s) 6061T6 aluminium bar 5.00" X .50" thick (M6061T6B0500X05000) Batch: 106858 IB 8-2-8
2.0	WATER JET	FLOW WATER JET  
		Comment: FLOW WATER JET 1-Cut as per Dwg D3729 Dwg Rev: <u>N/R</u> IB 8-2-8 Prog Rev: <u>U/R</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE   IB 8-2-8
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK   08/02/08 4/6
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1   08/02/08 4/6
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		1- Deburr if necessary SAID 08:02:08 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP BRACKET

Job Number: 37298

Part Number: D37291

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL 08.02.11 (6)
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 08.02.12
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 08.02.12
9.0	PACKAGING 1	PACKAGING RESOURCE #1 08.02.12
10.0	QC21	FINAL INSPECTION/W/O RELEASE 08.02.12 (6) 08.02.12

Job Completion



2008/2/12 (6)

U  
POSITIVE RECALL  
EFFECTIVE 08.02.01 AUTH [initials]  
RELEASED 08.02.01 DATE [initials]

SCRAPPED  
Qty 5  
W/L# 37582

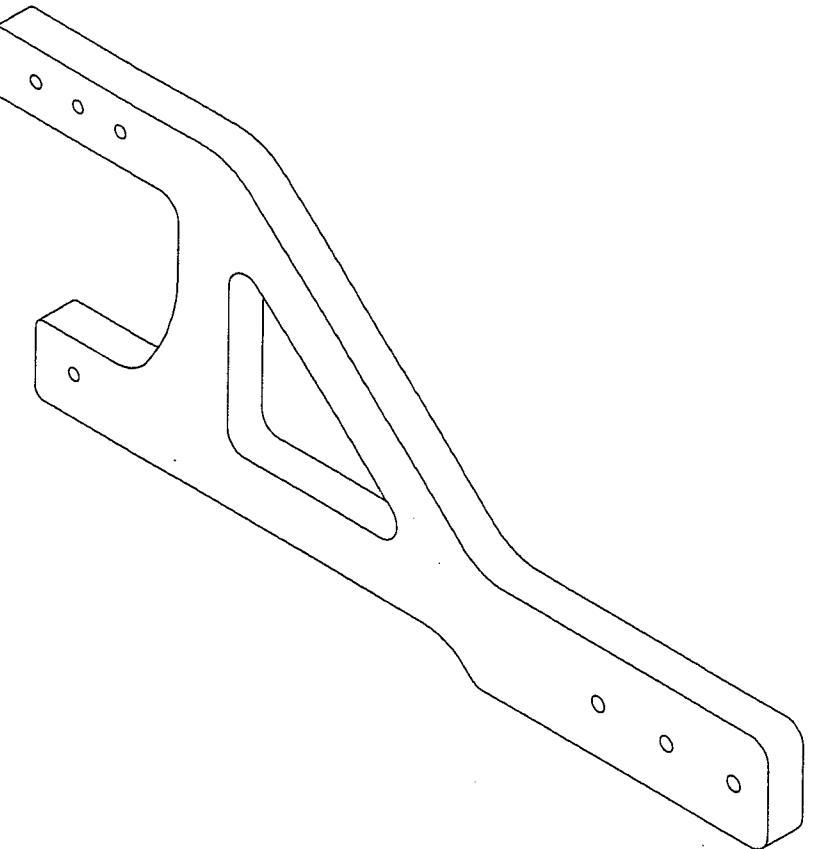
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

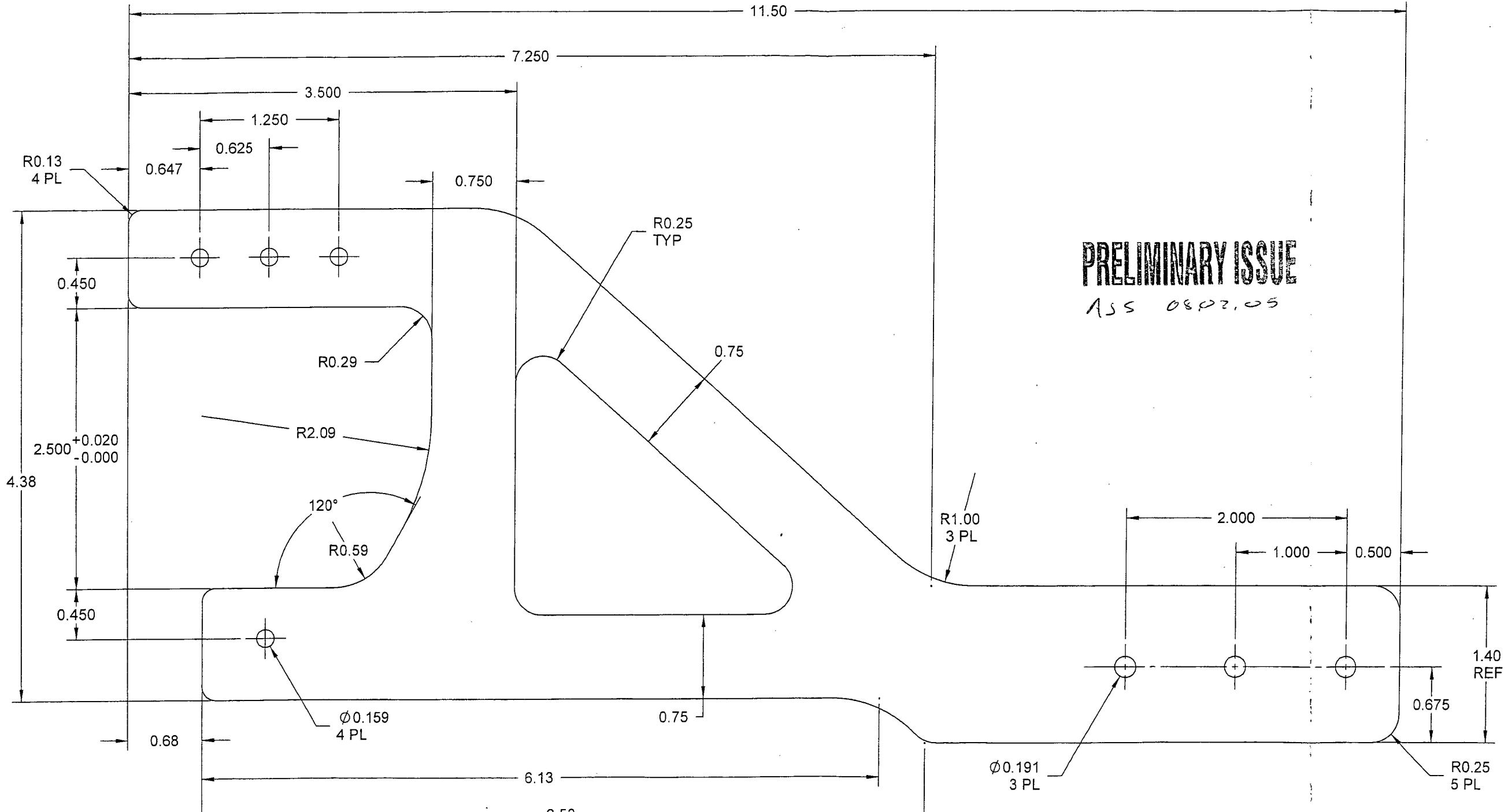
Prog done  
Est done



PRELIMINARY ISSUE  
AJS 08.02.05

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)  
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.00 lbs

A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS			
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3729	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.			STEP BRACKET	NTS
DATE	08.02.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3729-1 PLATE

DESIGN	AJSI	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3729	
APPROVED		REV. A	
DE APPR.		SHEET 2 OF 2	
DATE	08.02.04	TITLE	STEP BRACKET
		SCALE	1:1
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DART AEROSPACE LTD

Work Order: 37298

Description: STEP BRACKET

**Part Number:** D3729-1

Inspection Dwg: D3729-1 Rev: u/R

Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article

## Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ .159	+ .005 - .001	.164	X			
∅ .191	+ .005 - .001	.196	X			
.438	+/- .030	.4386	X			
11.50	+/- .030	11.50	X			
.450	+/- .010	.450	X			
.647	+/- .010	.645	X			
.625	+/- .010	.628	X			
1.250	+/- .010	1.250	X			
.750	+/- .010	.755	X			
2.500	+/- .010	2.498	X			
.450	+/- .010	.450	X			
.75	+/- .030	.755	X			
3.500	+/- .010	3.495	X			
6.53	+/- .030	6.53	X			
7.250	+/- .010	7.250	b			
2.000	+/- .010	2.000	b			
1.000	+/- .010	1.000	X			
.500	+/- .010	.500	X			
.675	+/- .010	.675	X			
1.40	+/- .020	1.403	b			

Measured by:

B

Audited by:

#### **Prototype Approval:**

Date:

Date: 8-2-8

Date: 08/07/08

Date: 01-02-11

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	